

Work Order ID 62900

Tuesday, October 12, 2010 3:41:22 PM



Page 1

Item ID: D2989-043

Accept



Setup Start



Revision ID:

Item Name: Basket Lid Assembly

Stop



Start Date: 10/12/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 10/22/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 10/10/12

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2989

Rev D

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- assemble all ribs in DT9446 jig, weld as per dwg D2989
2- tack weld mesh on basket as per dwg D2989 using DT9446 jig
3- to locate hinges and shims use D2989-041, weld as per dwg D2989
A/R ER316 S.S. Rod Batch: 1114649

[Signature] 10/10/19 (12)

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

[Signature] 10.10.19

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Item ID: D2989-043

Accept

Setup Start

Revision ID:

Stop

Item Name: Basket Lid Assembly

Start Date: 10/12/2010 Start Qty: 1.00

Cust Item ID:

Required Date: 10/22/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Identify as per dwg & Stock Location: _____ 0.00



Packaging

Memo

0.00

Packaging

160

QC21- Final Inspection - Work Order Release 0.00



QC

Memo

0.00

Quality Control

10/10/27
CMF
10-10-27

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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 62900

Parent Item: D2989-043

Parent Item Name: Basket Lid Assembly



Start Date: 10/12/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:I Removed D2989-041 05-11-03 JLM
 IPP Rev:J 08-08-29 revC as per dwg DD verified by:EC
 IPP Rev:K 08-09-24 plug holes prior to powder coating DD verified by:EC
 IPP Rev:L 08-12-02 revD as per dwg DD verified by:

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|-----------------|-------------|--------------|---------------|----------------|--------|
| J D2221-1 Rib | | Manufactured | No | | | 100 | Each | 14.0000 | 1 | 1 | | 10/10/14 | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | WA | | 14 | | | | | | | |
| | | | | 61091 | | 2 | | | | | | | |
| | | | | 61424 | | 12 | | | | | | | |
| J D2989-3 Rib | | Manufactured | No | | | 100 | Each | 5.0000 | 1 | 1 | | 10/10/14 | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | WA | | 5 | | | | | | | |
| | | | | 59006 | | 1 | | | | | | | |
| | | | | 59034 | | 1 | | | | | | | |
| | | | | 61393 | | 3 | | | | | | | |
| J D2989-4 Rib | | Manufactured | No | | | 100 | Each | 3.0000 | 1 | 1 | | 10/10/14 | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | WA | | 3 | | | | | | | |
| | | | | 61394 | | 3 | | | | | | | |

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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 62900

Parent Item: D2989-043


Parent Item Name: Basket Lid Assembly

Start Date: 10/12/2010

Required Date: 10/22/2010

Start Qty: 1.00


Required Qty: 1.00

✓ D2989-5 Manufactured No 100 Each 8.0000 2 2

 Rib

Location Loc Qty Loc Code

WA 8
 61396 4
 62367 4


②

✓ D3182-1 Manufactured No 100 Each 12.0000 2 2

 Hinge

Location Loc Qty Loc Code

WA 12
 61395 2
 62358 6
 62365 4


②

✓ D3442-3 Manufactured No 100 Each 6.0000 2 2

 Shim

Location Loc Qty Loc Code

WA 6
 61176 4
 61756 2

②

✓ D3827-041 Manufactured No 100 Each 9.0000 1 1

 Rib Assembly (Inboard)

Location Loc Qty Loc Code

WA 9
 61177 3
 61758 6

①

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Shop Packet Print

Page 2

| W/O: | | WORK ORDER CHANGES | | | | | |
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Picklist Print

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Page 3

Work Order ID: 62900

Parent Item: D2989-043

Parent Item Name: Basket Lid Assembly

Start Date: 10/12/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

✓ D3832-5 Manufactured No 100 Each 4.0000 1 1



 Mesh (Lid)  *SS 10/10/18*

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| WA | 4 | |
| 60671 | 1 | |
| 61759 | 3 | |



✓ D3833-5 Manufactured No 100 Each 7.0000 2 2

 Mesh (Lid End)  *SS 10/10/18*

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| WA | 7 | |
| 53722 | 1 | |
| 60673 | 2 | |
| 61317 | 4 | |

✓ D3838-041 Manufactured No 100 Each 3.0000 1 1

 Rib Assembly (Basket Lid, LH)  *SS 10/10/14*

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| WA | 3 | |
| 61397 | 3 | |

SS D3838-042 Manufactured No 100 Each 1.0000 1 1

 Rib Assembly (Basket Lid, RH)  *SS 10/10/14*

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| WA | 1 | |
| 61398 | 1 | |

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Shop Packet Print

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| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

D2989-043 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

D2989-041 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: D2989-041 = 26.50 lbs; D2989-043 = 15.50 lbs
 - 8) WELD PER DART QSI 004

| ITEM | QTY -041 | QTY -043 | P/N | DESCRIPTION |
|------|----------|----------|-----------|---------------------------|
| 1 | X | | D2989-041 | BASKET LID ASSEMBLY |
| 2 | | X | D2989-043 | BASKET LID ASSEMBLY |
| 3 | 1 | | D2506 | LABEL PLATE |
| 4 | 1 | | D2512-7 | RIB |
| 5 | 2 | | D2581 | MOUNTING BRACKET |
| 6 | | 1 | D2989-3 | RIB |
| 7 | | 1 | D2989-4 | RIB |
| 8 | | 2 | D2989-5 | RIB |
| 9 | 2 | | D2989-13 | RIB |
| 10 | 2 | 1 | D2989-17 | RIB |
| 11 | 2 | | D2989-19 | RIB |
| 12 | | 2 | D3182-1 | HINGE |
| 13 | | 2 | D3442-3 | SHIM |
| 14 | | 1 | D3827-041 | RIB ASSY (INBOARD) |
| 15 | 1 | | D3832-3 | MESH, BASKET LID |
| 16 | | 1 | D3832-5 | MESH, BASKET LID |
| 17 | 2 | | D3833-3 | MESH, LID END |
| 18 | | 2 | D3833-5 | MESH, LID END |
| 19 | 1 | | D3836-041 | RIB ASSY (BASKET LID, LH) |
| 20 | 1 | | D3836-042 | RIB ASSY (BASKET LID, RH) |
| 21 | | 1 | D3838-041 | RIB ASSY (BASKET LID, LH) |
| 22 | | 1 | D3838-042 | RIB ASSY (BASKET LID, RH) |
| 23 | 1 | | D3852-041 | RIB ASSEMBLY |
| 24 | 1 | | D3852-042 | RIB ASSEMBLY |

RELEASED
08/11/18

| D | REVISED -041/-043 PARTS LISTS AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); D3836-041 REPLACES D2989-9/-15; D3836-042 REPLACES D2989-10/-15; D3838-041 REPLACES D2989-1/-7; D3838-042 REPLACES D2989-2/-7; D3852-041 REPLACES D2989-11; D3852-042 REPLACES D2989-2; REMOVED D327-3 (NOW INSTALLED ON D3836 DWG), D2989-9/-10 (NOW ON D3836 DWG), D2989-1/-2/-7/-15 (NOW ON D3838 DWG) AND D2989-11/-12 (NOW ON D3852 DWG). REASON: TO SATISFY "LEAN MANUFACTURING" PROGRAM | MB | 08.09.24 |
|---|--|-----|----------|
| C | FRAME MATERIAL WAS 0.060 WALL; MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT AND CURRENT DRAFTING STANDARD | AJS | 08.05.20 |
| B | ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS | PH | 05.06.07 |
| A | NEW ISSUE | DS | 00.10.27 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | DS | | |
| DRAWN | | | |
| CHECKED | AJS | | |
| MFG. APPR. | | | |
| APPROVED | | | |
| DE APPR. | | | |
| DATE | 08.09.24 | | |
| DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D2989 TITLE BASKET LID ASSEMBLY REV. D SHEET 1 OF 5 SCALE NTS <small>COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small> | | | |

SHOP COPY

REV. 1

ENG.

CTR

CTO

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02900

Photo

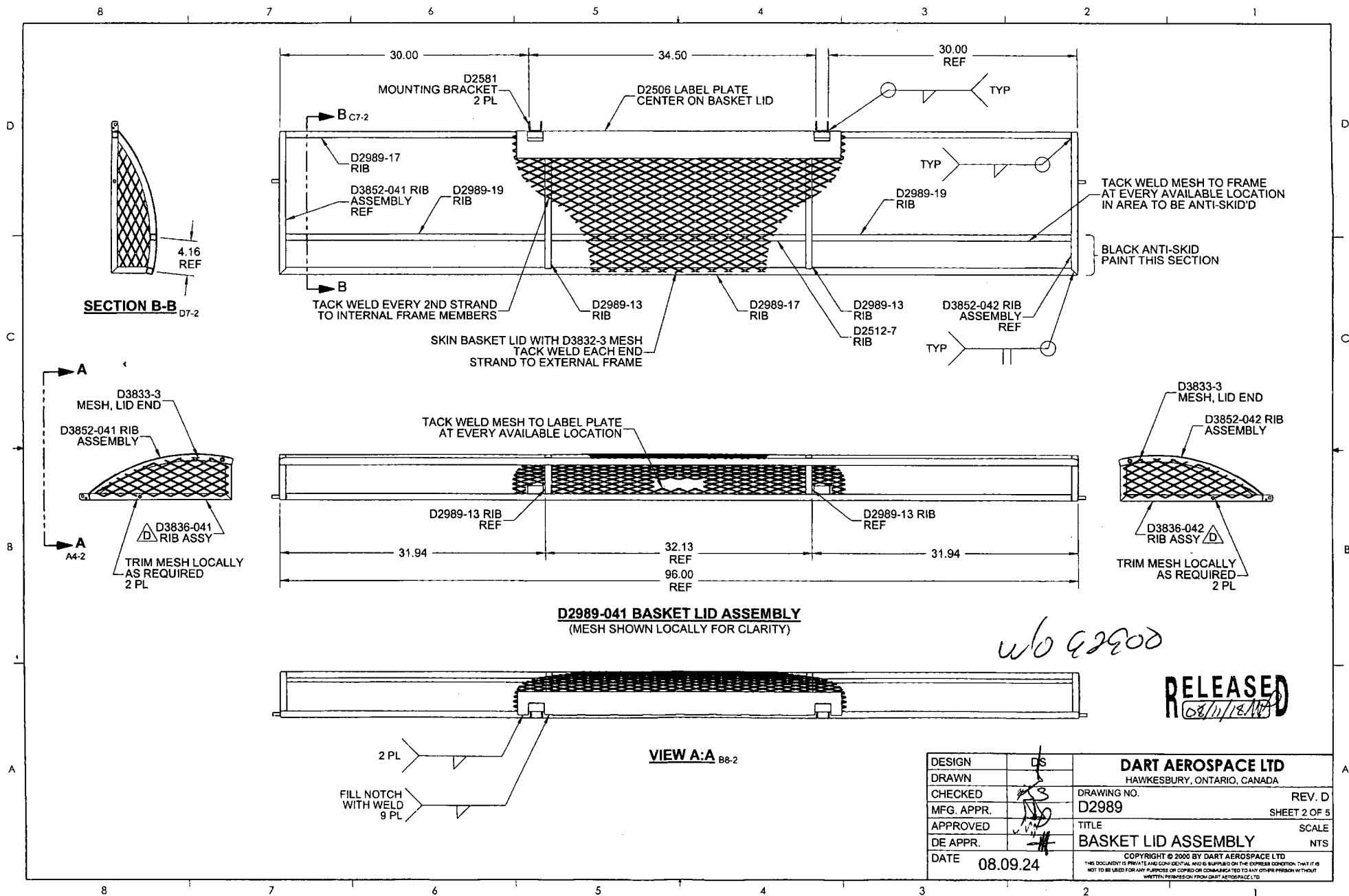
| W/O: | | WORK ORDER CHANGES | | | | | |
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



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| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
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| MFG. APPR. | | D2989 | SHEET 2 OF 5 |
| APPROVED |  | TITLE | SCALE |
| DE APPR. |  | BASKET LID ASSEMBLY | NTS |
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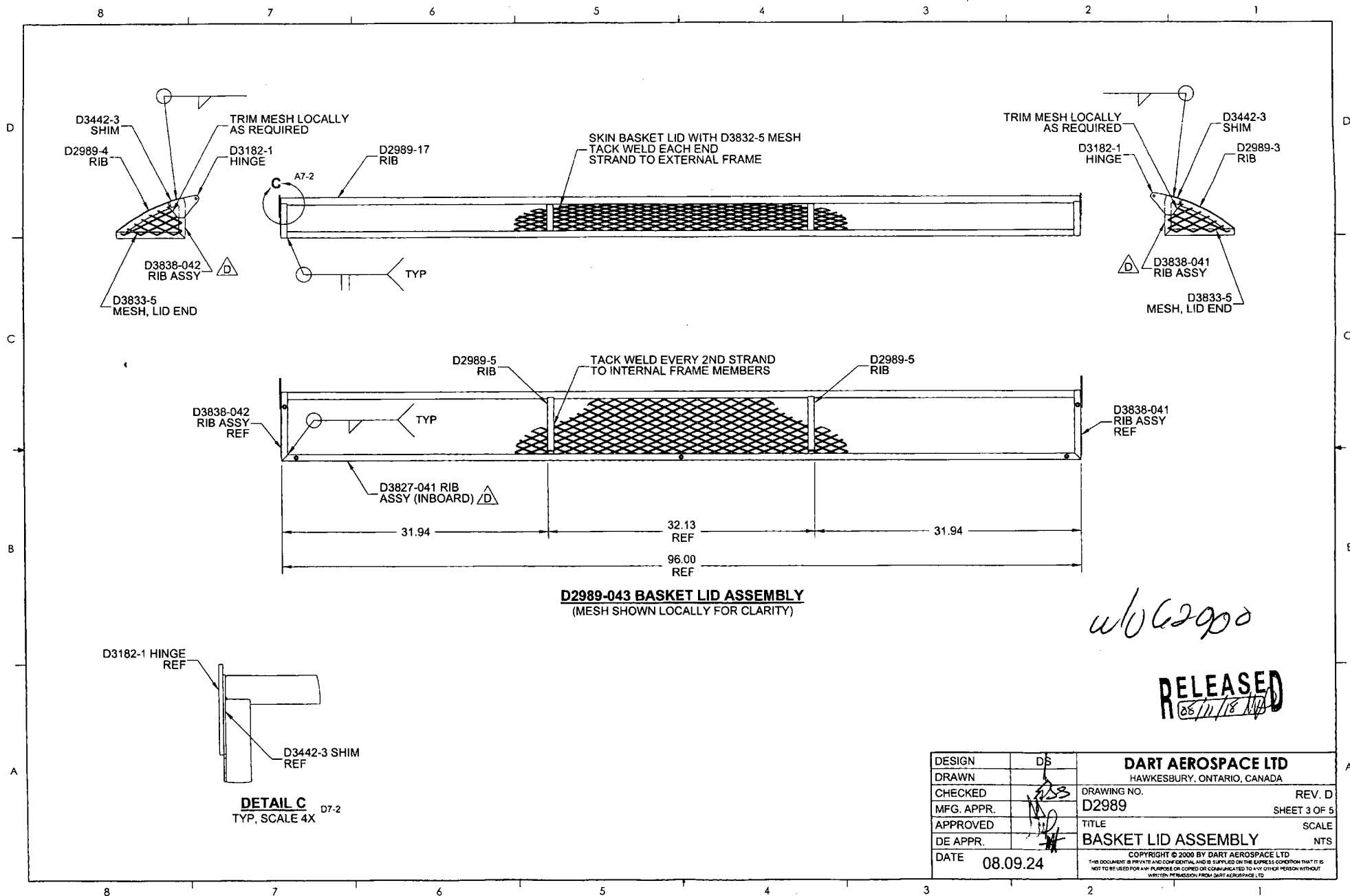
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NOTE: Date & initial all entries



D2989-043 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

w/062900

RELEASED
08/11/18

| | | | |
|------------|--------------------|--|-----------|
| DESIGN | DS | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | <i>[Signature]</i> | DRAWING NO. D2989 | REV. D |
| MFG. APPR. | <i>[Signature]</i> | SHEET 3 OF 5 | |
| APPROVED | <i>[Signature]</i> | TITLE BASKET LID ASSEMBLY | SCALE NTS |
| DE APPR. | | COPYRIGHT © 2000 BY DART AEROSPACE LTD | |
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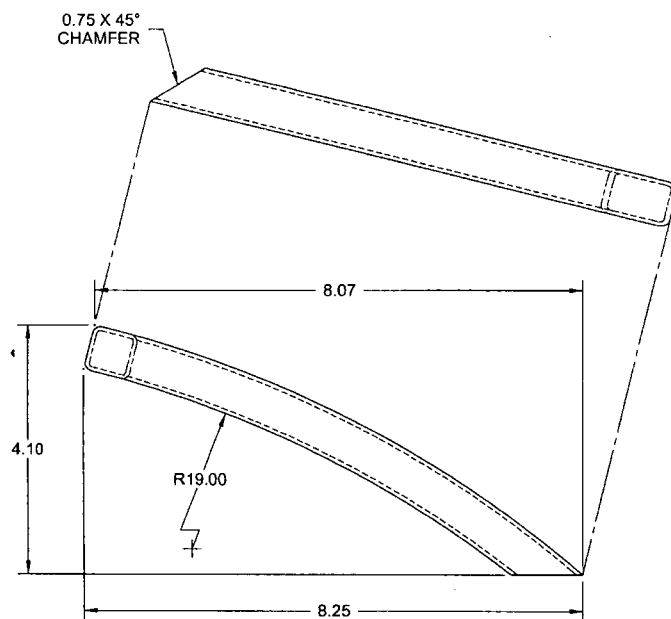
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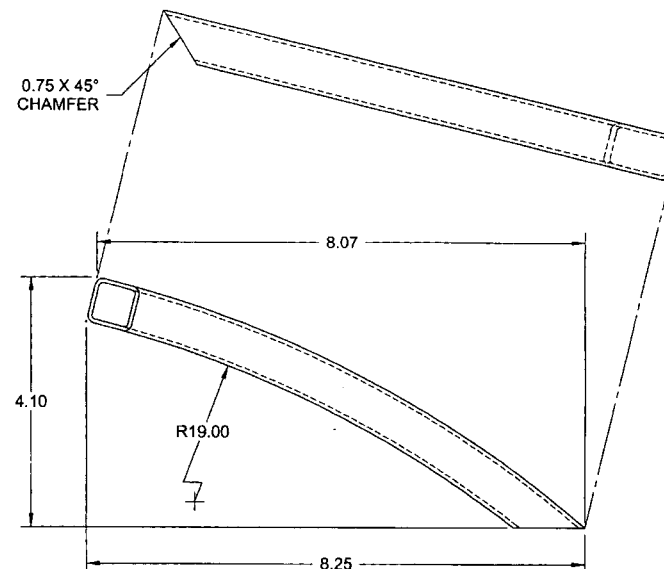
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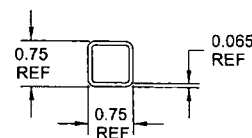
D2989-3 RIB



D2989-4 RIB



elo 62900

RELEASED
08/11/18 NW



TYPICAL SECTION VIEW

- NOTES:**
- 1) MATERIAL: D3166-3 BASKET HOOP
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 8) WEIGHT: D2989-3/-4 = 0.39 lbs;

| | | | |
|--|---|--|--------------|
| DESIGN | DS | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED |  | DRAWING NO. | REV. I |
| MFG. APPR. | | D2989 | SHEET 4 OF 5 |
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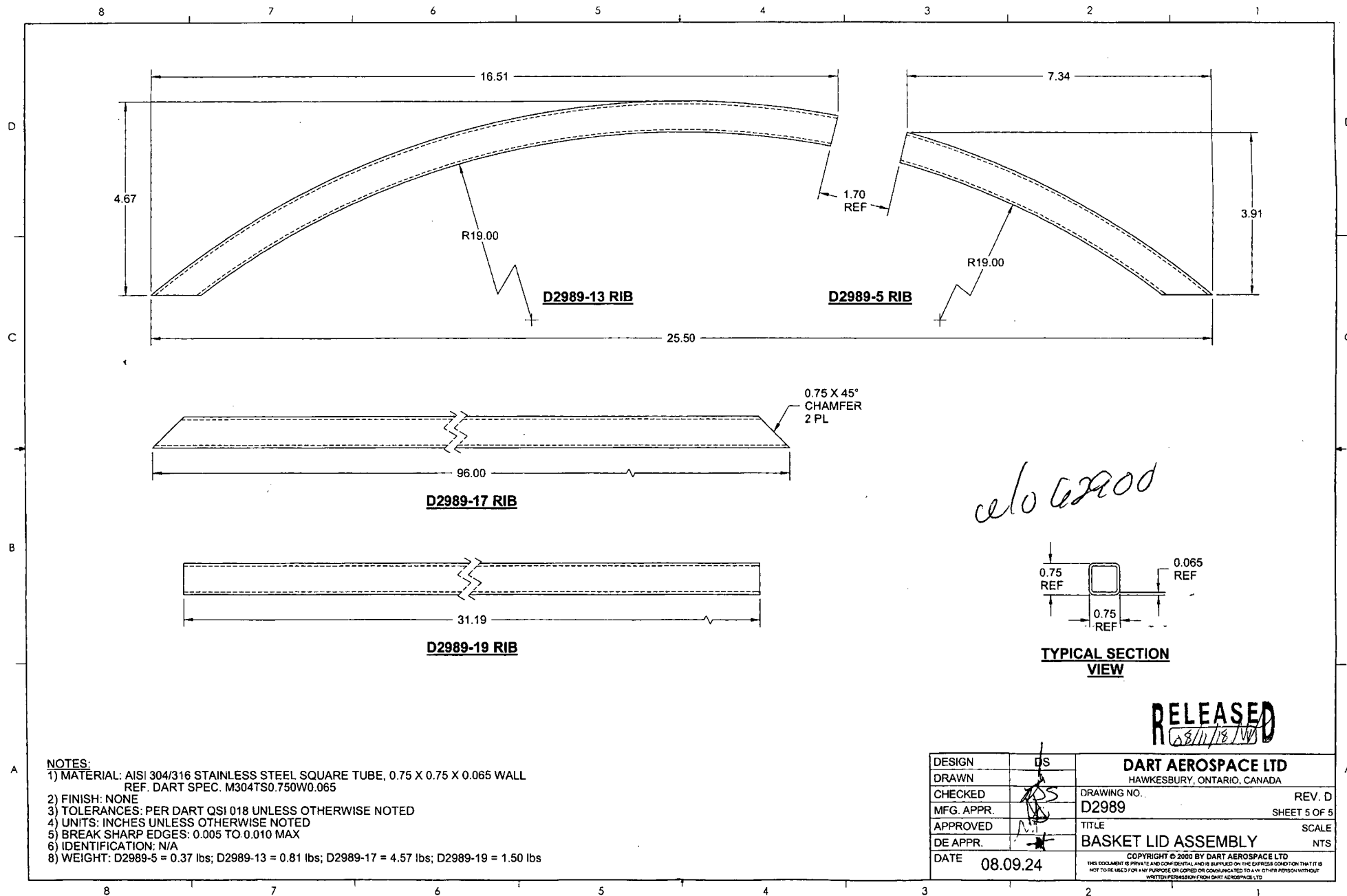
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| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries



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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries